

Date: Wednesday, 13/08/2008 11:56:12 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FRONT RAIL, RH
<b>Job Number</b> :	41218		
<b>Estimate Number</b> :	13493		
<b>P.O. Number</b> :		<b>Part Number</b> :	D37662
<b>This Issue</b> :	13/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3766 REVB
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40864	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 08.8.13</u>	<b>Due Date</b> :	14/08/2008
<b>Comment</b> :	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W



Comment: Qty.: 2.9323 f(s)/Unit Total: 2.9323 f(s)

6061T6 RD TUBE 1.00 X .188W

batch: M104779mmwSAD08/08/13

①

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to lenght as per dwg D3766

SAD08/08/13

①

2-drill holes thru to finish size as per dwg D3766

3- deburr

mmw08/08/13

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/13  
mmw  
08/08/13

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mmw08.08.13

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mmw  
08/08/13

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/08/2008 11:56:12 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, RH

Job Number: 41218

Part Number: D37662

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

S/S 08/08/14

①

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/08/14

①

Job Completion



MF 08-08-14

# Dart Aerospace Ltd

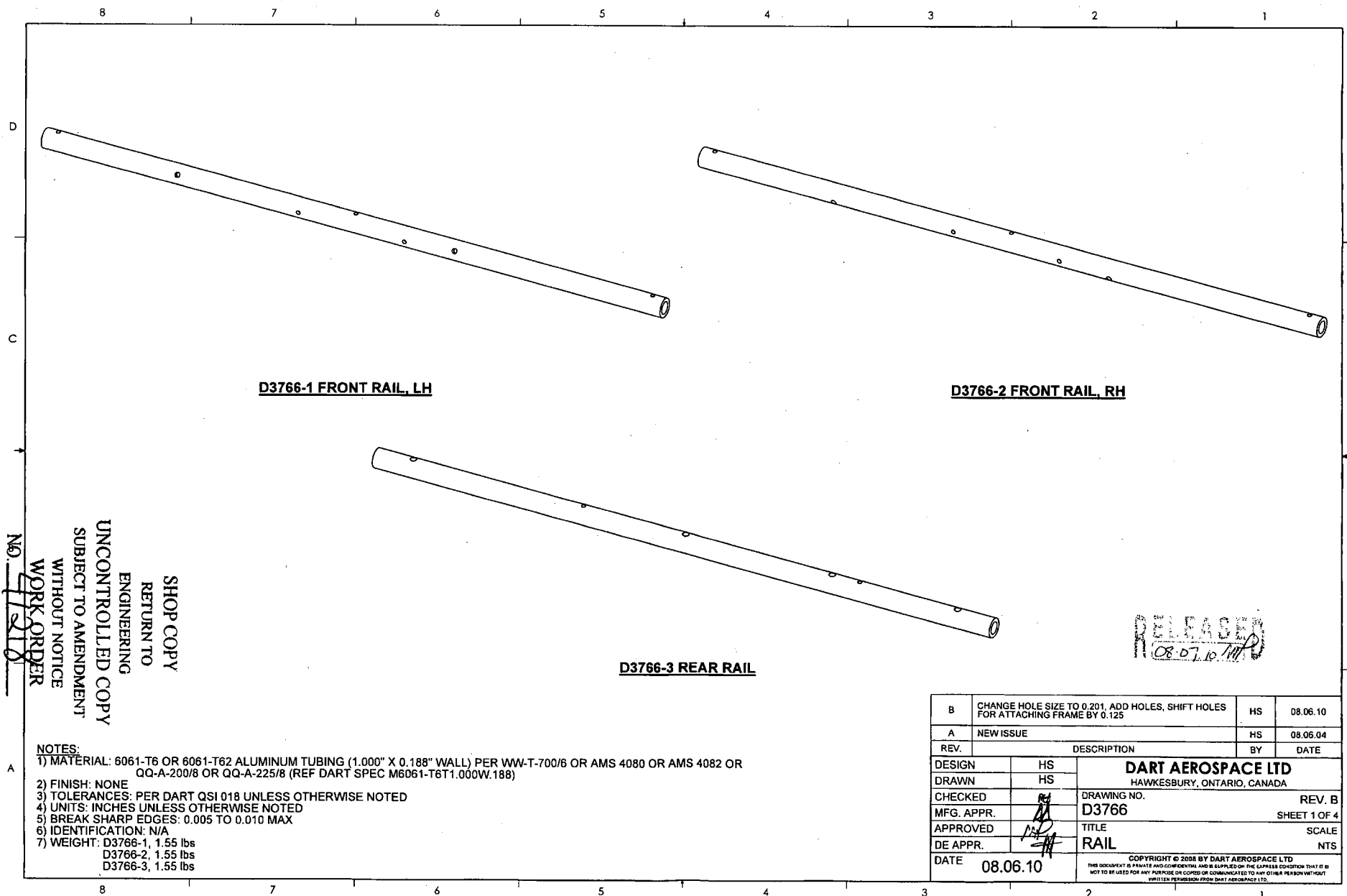
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 47218

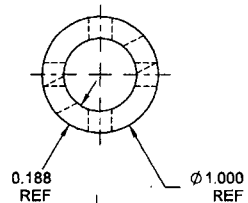
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WORK ORDER

**NOTES:**

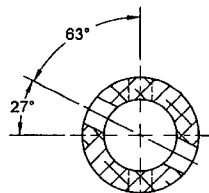
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs  
D3766-2, 1.55 lbs  
D3766-3, 1.55 lbs

RELEASED  
08.07.10

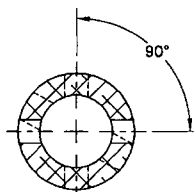
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3766</b> TITLE <b>RAIL</b> SCALE <b>NTS</b> REV. B SHEET 1 OF 4	
DRAWN	HS		
CHECKED	HS		
MFG. APPR.	HS		
APPROVED	HS		
DE APPR.	HS	DATE <b>08.06.10</b> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



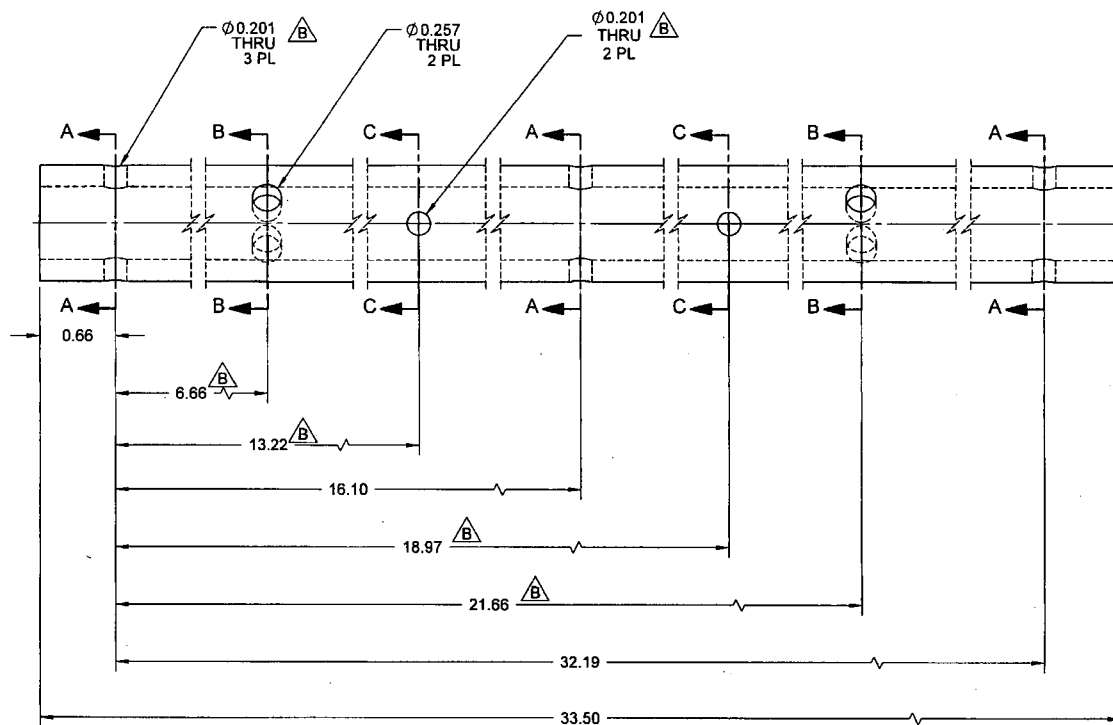
**SECTION A-A**



**SECTION B-B**



**SECTION C-C**

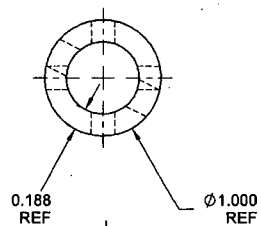


**D3766-1 FRONT RAIL, LH**

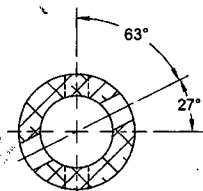
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MFG. APPR.		<b>D3766</b>	SHEET 2 OF 4
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DE APPR.		<b>RAIL</b>	NTS
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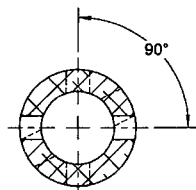
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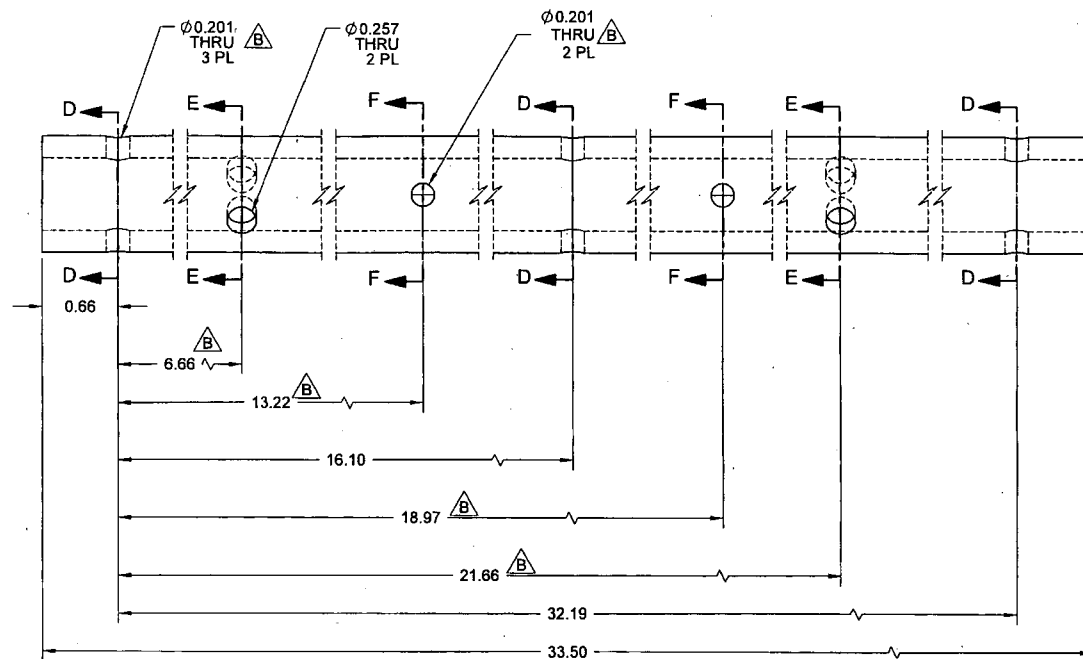
**SECTION D-D**



**SECTION E-E**



**SECTION F-F**



**D3766-2 FRONT RAIL, RH**

RELEASED  
08.07.10

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CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	<b>D3766</b>	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
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8 7 6 5 4 3 2 1

D

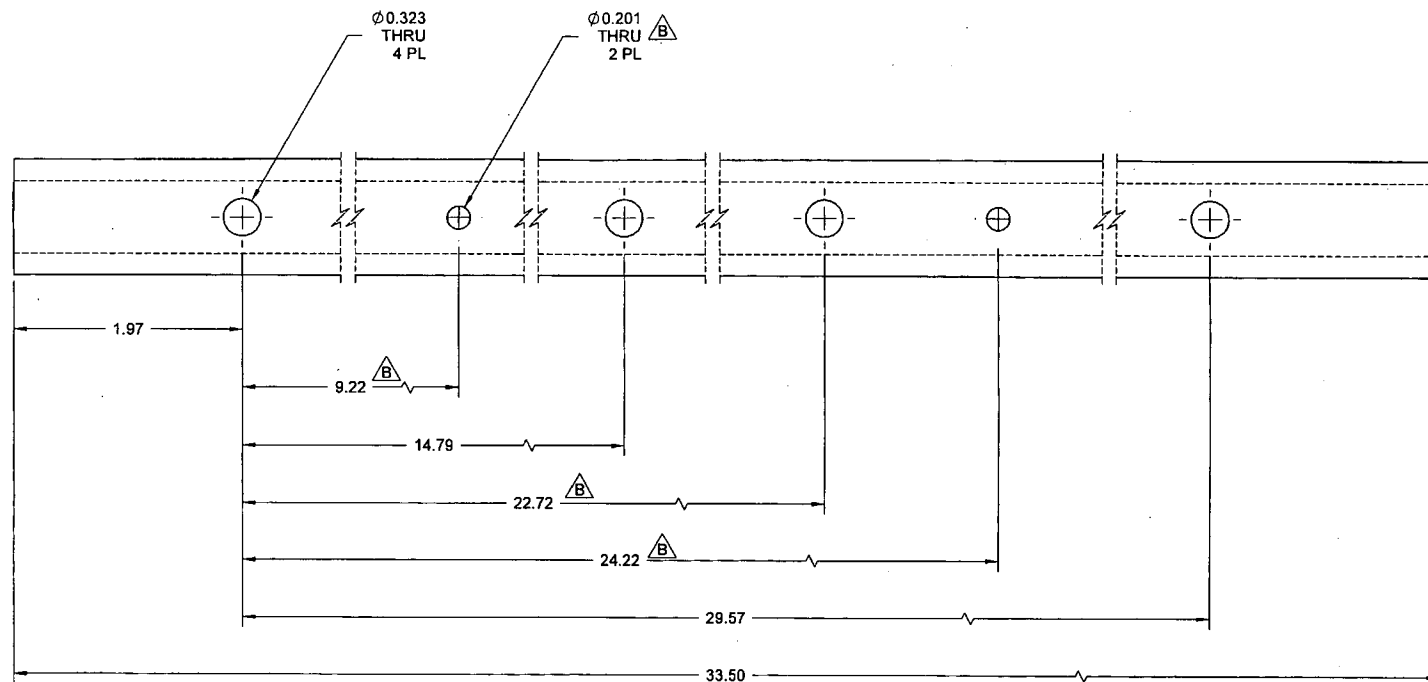
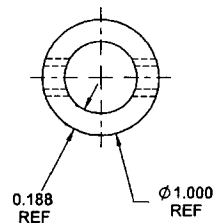
C

B

D

C

B



**D3766-3 REAR RAIL**

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08.06.10 MPD

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DRAWN	HS		
CHECKED	MPD	DRAWING NO.	REV. B
MFG. APPR.	MPD	<b>D3766</b>	SHEET 4 OF 4
APPROVED	MPD	TITLE	SCALE
DE APPR.	MPD	<b>RAIL</b>	NTS
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7 6 5 4 3 2 1